

Work Order ID 62113

September 16, 2010 9:21:48 AM

BLUE



Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 9/16/10 Start Qty: 3.00



Cust Item ID:

Required Date: 9/22/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2932

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. 11-Inspect part number and batch number are programmed correctly. 12-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 13-Machine Step No 2 of Folio and visually inspect as per

[Signature] 3 10/09/19 *[Initials]*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

[Signature] 3 10/09/19 *[Initials]*

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

[Signature] 3 10/09/19 *[Initials]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62113

September 16, 2010 9:21:48 AM



Page 2

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Item Name: Saddle RH Out, 206

Start Date: 9/16/10 Start Qty: 3.00



Cust Item ID:

Required Date: 9/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

OK 09/21

3

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7/11 10/09/21

3 9

151

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B *114424*

PAINT DELFLEET BLUE B *115509*

CLEAR DELFLEET B *115506*

W 10.09.24 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62113

September 16, 2010 9:21:50 AM



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Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 9/16/10 Start Qty: 3.00



Cust Item ID:

Required Date: 9/22/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

161

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

ET 10-09-27 (73)

170

Identify as per dwg & Stock Location: 421

0.00



Packaging

Memo

0.00

Packaging

10/09/27 (3)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/27
MF 10-9-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 16, 2010 9:21:46 AM

Page 1

Work Order ID: 62113

Parent Item: D2932-2

Parent Item Name: Saddle RH Out, 206



Start Date: 9/16/10

Required Date: 9/22/10

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: B1100.06.261 New DWG rev (mpp 2069): EC
IPP Rev: C As per Rev C 07-03-19 JLM 11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003

Manufactured No

100

Each

43.0000

1

3



Saddle Billet, 7075



[Signature] 10/09/19

Location

Loc Qty

Loc Code

MAT042

43

✓ 59196

3

61250

40

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 62113
Description: 206 Saddle, Inboard, Right side	Part Number: D2933-2 D2932-2
Inspection Dwg: D2933 Rev. C	Page 1 of 1

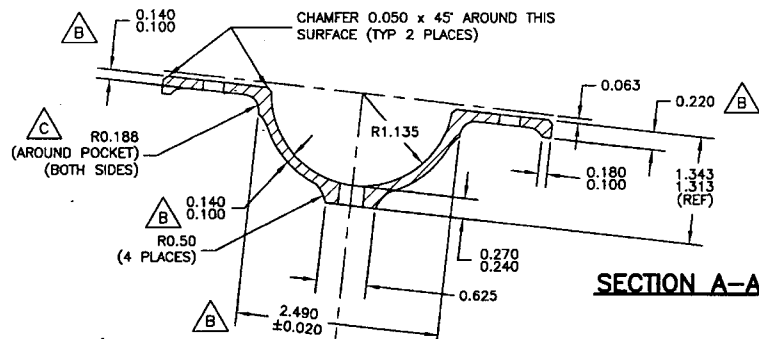
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.124	0.124	0.124		118-120	Deep Mic
B	0.100	0.140		0.123	0.124	0.125			"
C	0.100	0.140		0.115	0.118	0.118			"
D	0.210	0.230		0.223	0.224	0.224		DJP-02	Mic
E	1.245	1.255		1.250	1.250	1.250		DJP-11	Vern
F	1.245	1.255		1.250	1.250	1.250			"
G	2.495	2.505		2.500	2.500	2.500			"
H	0.510	0.515		0.510	0.510	0.510			"
I	1.572	1.582		1.577	1.577	1.577			"
J	2.495	2.505		2.500	2.500	2.500			"
K	0.257	0.262		0.259	0.259	0.259			"
L	0.312	0.317		0.317	0.317	0.317			"
M	0.235	0.240		0.237	0.237	0.237		DJP-02	Mic
N	0.100	0.140		0.110	0.115	0.111			"
O	0.540	0.560		0.547	0.552	0.549		DJP-11	Vern
P	0.490	0.510		0.500	0.506	0.508			"
Q	3.715	3.725		3.720	3.720	3.720			"
R	2.470	2.510		2.493	2.495	2.495			"
S	0.240	0.270		0.247	0.248	0.249			"
T	0.100	0.180		0.130	0.130	0.130			"
U	1.625	1.635		1.630	1.630	1.630			"
V	1.362	1.372		1.367	1.367	1.367			"
W	0.316	0.321		0.318	0.318	0.318			"
X	1.125	1.145		1.139	1.140	1.139			Dial
Y	1.565	1.585	DT8695 A/B	1.5765	1.577	1.576			"
Z	0.178	0.198		0.188	0.188	0.188			Rad Gage
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

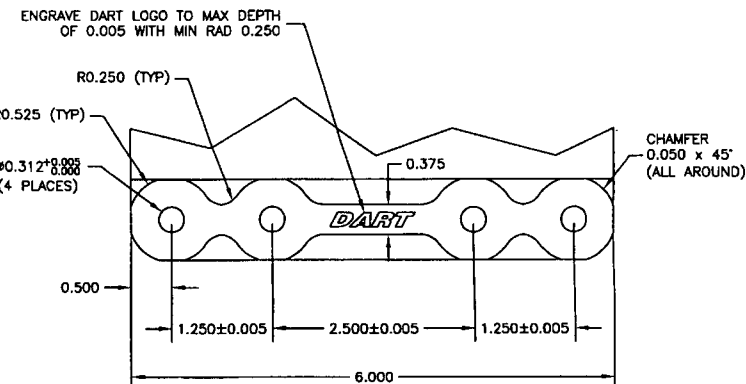
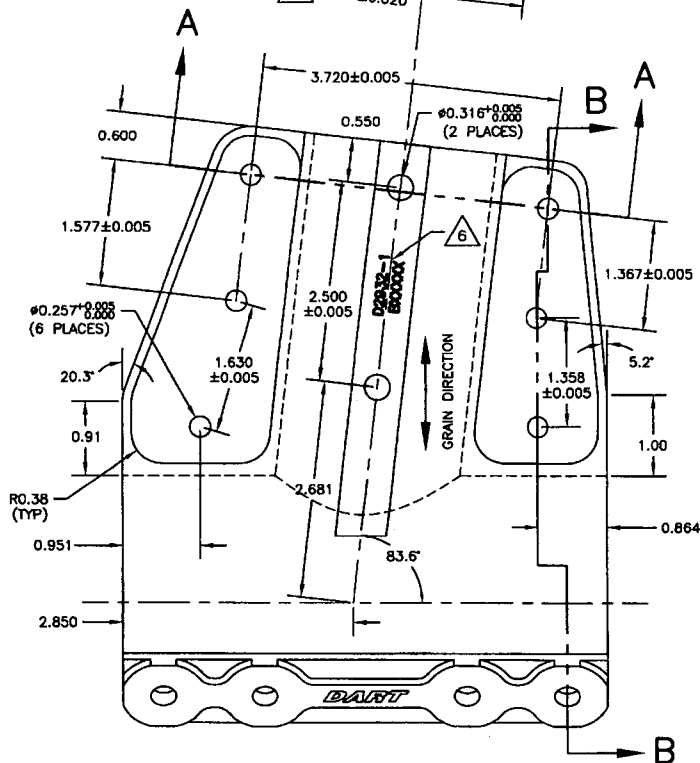
Measured by: <i>STP</i>
Date: 10/09/19

Audited by: <i>10/09/19</i>
Date: 10/09/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

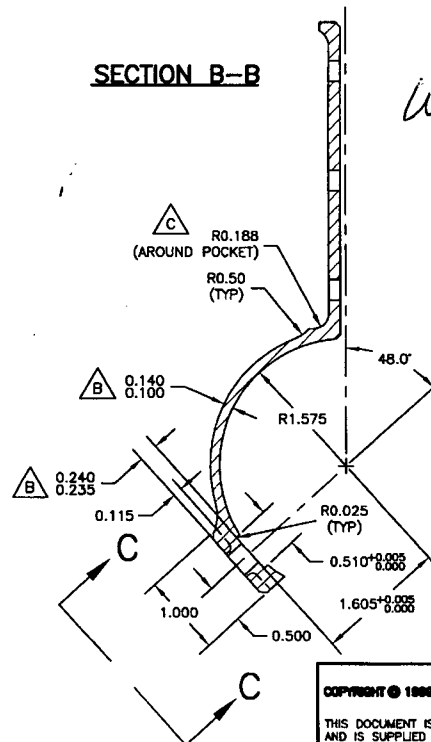


SECTION A-A



VIEW C-C

SECTION B-B



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE OUTSIDE
		DRAWING NO. D2932
		REV. C
		SHEET 1 OF 1
		SCALE 2:3

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DART DART AEROSPACE USA, INC.
BELLEVUE, WA

RELEASED

07-02-12